

# EUROPEAN PATENT OFFICE

## Patent Abstracts of Japan

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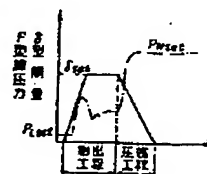
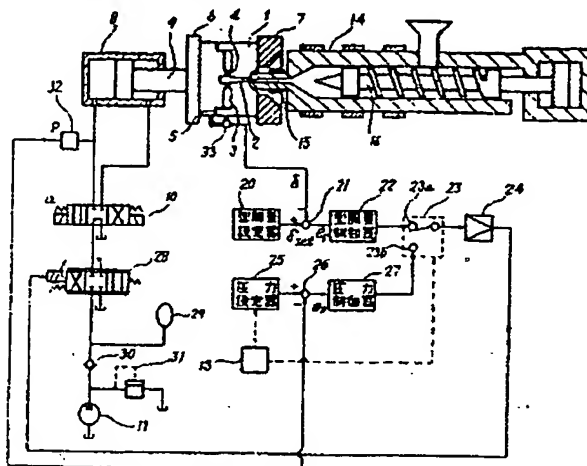
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INVENTOR : ASAI HIROSHI;

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TITLE : METHOD AND DEVICE FOR  
INJECTION AND COMPRESSION  
MOLDING



ABSTRACT : PURPOSE: To stabilize the allowance of compression of molten resin in a cavity as well as the dwell of the cavity, by a method wherein a mold clamping pressure is controlled through a closed loop control so that the amount of mold opening keeps a predetermined value upon injection process. (X) 1

CONSTITUTION: A mold opening amount controller 22 controls a difference  $e\delta$  between a set mold opening amount and a mold opening amount  $\delta$ , detected by a mold opening amount detector 33 arranged on a mold 1, through proportional, integral and differential control and controls a servo valve 28 through a changeover switching circuit 23. On the other hand, a pressure detector 25, in which a low pressure mold clamping pressure  $PL_{set}$  upon starting injection and a mold clamping pressure  $PM_{set}$  in a compression process are set, is provided while a pressure detector 32, which detects a mold clamping pressure  $P$ , is provided in an oil passageway at the mold clamping side of a mold clamping cylinder 8. The mold clamping pressure  $P$ , actually detected, is compared with the mold clamping pressures  $PL_{set}$ ,  $PM_{set}$  in the low pressure mold clamping upon starting injection and the compression process, which are set previously, in a comparator and the difference ( $e\delta$ ) is outputted while said difference is controlled by the pressure controller 27 through proportional, integral and differential control and the output thereof is inputted into the changeover switching circuit 23 in the circuit of the title device. (X) 7

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(X) 1 + (X) 2

↳ Aufheben der Form infolge des Erzeugnisdrucks